

Date: Friday, 10/13/2006 9:30:53 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB		
Job Number	: 28973					
Estimate Number	: 10498					
P.O. Number	: N/A		Part Number	: D2739		
This Issue	: 10/13/2006	S.O. No. : N/A	Drawing Number	: D2739 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C		
Previous Run	: 28256		Material	: N/A		
Written By	:		Due Date	: 10/30/2006		
Checked & Approved By	: <u>KJ</u> 06 10 13		Qty:	4		Um: Each
Comment	: Est Rev: C 02.11.28 Rerformat KJ					
	Est Rev: D 06-03-21 As Per Rev C JLM					

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin

Extrusion 'I-Beam' thin

Pick:

Qty E

Qty Part Number Description Batch
1 D2600-5 Web B244

20 LANDING GEAR 1 LANDING GEAR RESOURCE 1

A standard linear barcode is located at the bottom of the page, consisting of vertical black lines of varying widths on a white background.

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Dhurr

3.0 QC5 INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

3E 06-10-18 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/10/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m.l 06/10/18

(4)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-10-18

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock
Location: *LG*

BE 06-10-18

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

IS 06/10/19

Job Completion



2 06/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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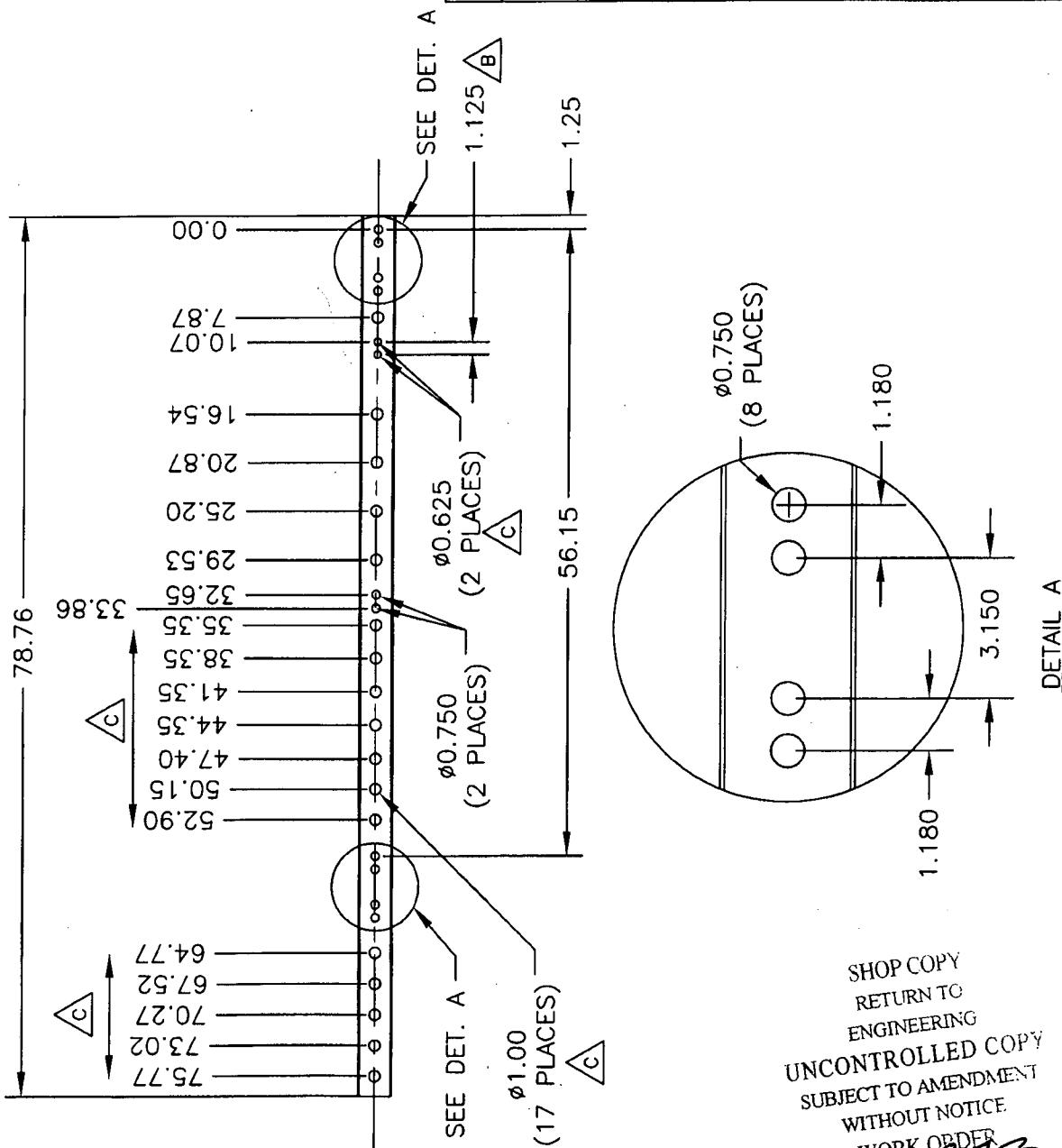
NOTE: Date & initial all entries

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C	SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE		
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS		
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS		

RELEASED
de-02-57 1

06-02-07



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28973

D2739 WEB
1) MATERIAL
2) FINISH:
3) ALL DIM
4) TOLERANCE

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